

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029528**Date Inspected:** 23-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed on the various Complete Joint Penetration (CJP) groove welds of the East and West Orthotropic Box Girders (OBG's).

The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

At the start of the shift this QAI observed the following:

This QAI witnessed the Quality Control (QC) Inspector William Sherwood perform the Magnetic Particle Testing (MPT) of the lifting rod closure plate weld identified as EB-SLLH-10 and the adjacent lifting lug removal areas of the longitudinal shear plate identified as EB-SLL-10. This QAI performed the Magnetic Particle (MPT) verification inspections of lifting rod closure plate weld EB-SLLH-10 and the adjacent lifting lug removal areas of the longitudinal shear plate identified as EB-SLL-10. See the attached TL6028 MT report for details. This QAI also performed Ultrasonic Testing/UT of the EB-SLLH-10 lifting rod closure plate weld. See the attached TL6027 UT report for details. The welding and QC inspection was observed and verified by this QAI and appeared to be in compliance with the contract documents.

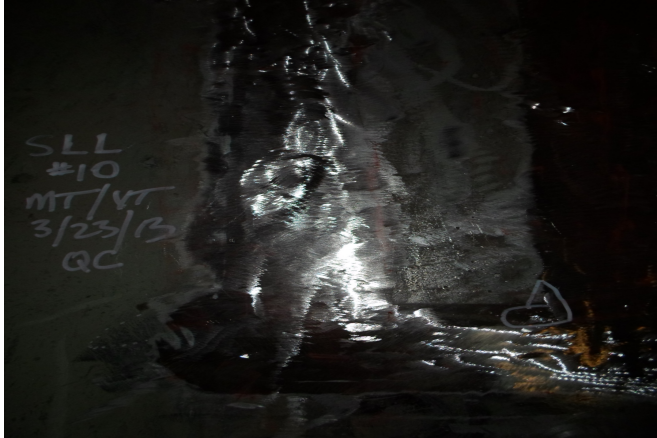
This QAI witnessed the preheating to 150F and 1G flat position welding completed of Deck Access Hole (DAH) weld 12E-PP116.5-E2 by welder Mike Jimenez #4671 utilizing E7018 4.0mm electrodes at 180 amperes as per WPS 1040C rev 1. The Quality Control (QC) Inspector Salvador Merino was present. The backgouging of the

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weld root to sound metal is in progress at this time. The 1G (flat position) portion of welding and QC inspection performed by Sal Merino was observed and verified by this QAI and appeared to be in compliance with the contract documents.

The digital photographs below illustrate some of the work activities observed on this date:



Summary of Conversations:

No significant conversations took place.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Morris, Monty
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Quality Assurance Inspector

Reviewed By:	Reyes, Danny
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QA Reviewer
